Salflex Polymers Ltd.

SALFLEX 622LI
22 % Talc- Reinforced COPP
Process Sheet

GENERAL

Good manufacturing practices should be employed while processing any plastic material. Avoid contact with the hot melt. Provide good ventilation to prevent inhalation of fume. Implement safe procedures for the operation of polymer processing equipment. Avoid contaminating the material with PVC or polyacetals. Those materials may emit noxious fume at high temperatures.

DRYING

Talc reinforced polypropylenes are hygroscopic and therefore adsorb atmospheric moisture. It is important that the pellets and any regrind be dried in a desiccating dryer prior to processing. Drying for 2-4 hours at 70-90°C (160-195°F) is recommended. This will improve part appearance and processing characteristics.

PROCESSING

This material is used for injection molding. Temperature settings for the process equipment are given below. They are general guidelines only. Typical value for screw speed is about 50% and may vary according to part size. Screw speeds may affect melt temperature as much as the machine temperature settings.

PROCESSING CONDITION

Processing Method	**Injection Molding**	
Set Points Temperature	**+/- 5 °C**	**+/- 10 °F**
Rear of Barrel	190-220	375-430
Middle of Barrel	200-230	390-445
Front of Barrel	210-240	410-465
Nozzle	220-240	430-465
Ideal Melt Temperature	200-220	390-430
Mold Temperature	27-60	80-140

REGRIND

The material is relatively heat stable and can be easily reprocessed. The best performance, when reprocessing regrind, will be achieved by grinding to uniform size in a grinder with sharp blades.

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1925 Wilson Ave., Weston, Ontario, M9M 1A9, Canada Tel: (416)741-0273 Fax: (416) 741-9453